

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010057**Date Inspected:** 26-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint ED1-6003-5-8B located on PCMK east tower strut. Welder was identified as 052493. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-485-SMAW-2G(2F)-FCM-repair-1.

FCAW welding of weld joints SSTL4-1G/L-42, 37 located inside PCMK south tower, lift 4, skin A, fit lug to stiffener at the bottom of 127M double diaphragm. Welder was identified as 054069. ZPMC QC was identified as CWI Chen Ying Xin (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joints SSTL4-1G/L-39, 48 located inside PCMK south tower, lift 4, skin A, fit lug to diaphragm at the bottom of 127M double diaphragm. Welder was identified as 040343. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-4333-TC-P4-F.

FCAW welding of weld joints NSTL3-3C/K-53, 54 located inside PCMK north tower, lift 3, at the corner of skin

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A and skin E, at the bottom of 89M double diaphragm. Welder was identified as 052075. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F for weld 54 and WPS-B-T-4332-TC-P4-F for weld 53.

FCAW welding of weld joint NSTL3-3D/K-49 located inside PCMK north tower, lift 3, at the corner of skin A and skin E, at the top of 89M double diaphragm. Welder was identified as 057266. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint ED1-A435B/C-8-22 located on PCMK east tower, lift 1, skirt plate. Welder was identified as 047701. ZPMC QC was identified as Zhan Bo (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint ED1-A435B/C-1-22 located on PCMK east tower, lift 1, skirt plate. Welder was identified as 040736. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint ED1-A435B/C-8-21 located on PCMK east tower, lift 1, skirt plate. Welder was identified as 042218. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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